

DEPARTMENT OF TRANSPORTATION

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch
690 Walnut Ave.St. 150
Vallejo, CA 94592-1133
(707) 649-5453
(707) 649-5493

Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Pursell, Gary**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-002046**Date Inspected:** 28-Dec-2007**Project Name:** SAS Superstructure**OSM Arrival Time:** 1500**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 2300**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Quinghua Min**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Components, Tower Mock-Up**Summary of Items Observed:**

The Caltrans Quality Assurance Inspector (QA), M. Paul Stovall, was present at Zhenhua Port Machinery Company (Z. P. M. C.), Changxing Island, Shanghai, China for the purpose of monitoring the fabrication of the SAS/San Francisco/Oakland Bay Bridge.

(Bay 3) QA Inspector M.Paul Stovall received a shift turnover directly from QA Inspector Paul Dawson stating that Zhenhua Port Machinery Company Quality Control (QC) personnel, had started a Magnetic Particle Test (MT) on Bottom Plate (BP)011, when QA arrived at the specified location, Z. P. M. C. Quality Control personnel, stopped work, and then left the area, leaving their equipment.

(Bay 3) Z. P. M. C. personnel were grinding the faying surfaces of WT stiffeners for Side Plate (SP)009.

(Bay 2) 114 meter Mock-Up, Z. P. M. C. Welder Chang Chuaneang--053870, welder had stopped just recently, there was no Interpreter, in the area, but the temperature was in excess of 230 degrees. Welding Procedure Specification (WPS)-345-FCAW-1G-(1F)-1, was going to be used for a weld repair. The QA Inspector found the QC Certified Welding Inspector (CWI), told him of the situation, he checked the temperature and told the Welder to not weld, until it had cooled down.

Summary of Conversations:

The qa inspector spoke with the qc CWI, i regards to the high temperature of the weld joint on the 114-meter Mock-Up, an Interpreter was present.

Comments

WELDING INSPECTION REPORT

(Continued Page 2 of 2)

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Mazen Wahbeh, (818) 292-0659, who represents the Office of Structural Materials for your project.

Inspected By:	Stovall,Paul	Quality Assurance Inspector
Reviewed By:	Cochran,Jim	QA Reviewer
